

Spline Milling Cutter Ø20 Z4

A02-010

The spline milling cutter form is ground with 2 profile clearancesurfaces. Before, on the preshaped blank, a roughing operation removes surplus of material up to an aequidistant stock of max 0.1 mm. Despite flute and gashoperation a front operation is necessary to clear the hollow end.



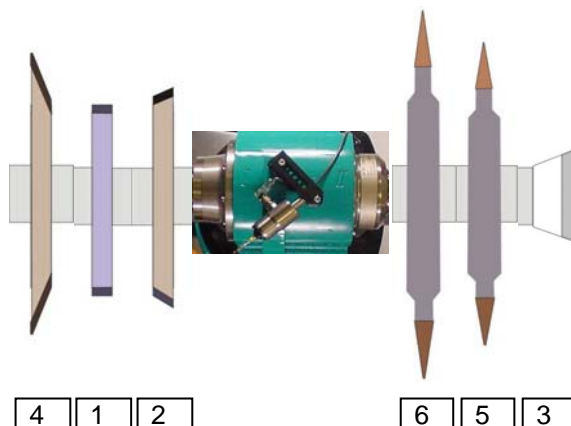
1. Cycletime for Production

Workpiece: Diameter 20 mm, Z 4, Length of cutting edge 22 mm, Helix angle 0° Material CARBIDE							
Operations							
Feed [mm/Min]	2000	50	80	70	50	70	100
Power [kW]		3	2	1	3	2	2
Cutting feed [m/s]		20	20	22	20	22	22
Used wheels							
Grinding time [s]	8	167	94	67	171	133	104
Total cycle time	12 Min 24						

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø125 D64
2	1V1 Ø125 D64
3	11V9 Ø75 D64
4	1V1 Ø125 D76 30°
5	14EE1 Ø100 D76V30°
6	14EE1 Ø150 D46V30°



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMA CFG **Coolant:** Synthetic Oil, pressure 6 bar
Control: Fanuc 310i **Software:** Quinto 5
Accessories:

Responsible engineer: OP. 11.5.11

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